



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61154**

Tuesday, August 10, 2010 8:40:57 AM

Page 2

Item ID: D2842-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Assembly RH, 206 Float

Start Date: 8/11/2010 Start Qty: 4.00

Required Date: 8/25/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S 10/08/17

Quality Control

Handwritten: 4 RM (circled) and signature

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

K 10-08-18

Hand Finishing

Handwritten: 4 and signature

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SAD 10-08-18

Quality Control

Handwritten: 4 (circled) and signature

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61154**

Tuesday, August 10, 2010 8:40:57 AM



Page 3

Item ID: D2842-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly RH, 206 Float

Start Date: 8/11/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Large Fab	0.00							
Large Fab	Memo	0.00				4	8		
Large Fab	I-Remove alodine prior to welding. <input type="checkbox"/> Weld end cap as per Dwg D2842. <input type="checkbox"/> A/R AL Rod Batch: <u>M112860</u> <input type="checkbox"/> 2-Grind end cap weld flush.								
170 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
180 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

10-08-19

10-08-19

81010617

24  
RH

PTO = 2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/08/20	151	TOUCH-up Alodine on STEP ASPES QSI005 Chemical Conversion Coat per QSI0005. 4.1	JH	10/08/20	X4 RM		S 10/08/20

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61154**

Tuesday, August 10, 2010 8:40:57 AM



Page 4

Item ID: D2842-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly RH, 206 Float

Start Date: 8/11/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

10:15

325° FINISH TIME:

OVEN TEMPERATURE:

10:45

4 16R 10-8-24.

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

ml 10 08 25 (4)

210



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI  
005 4.1 Batch: 115028

ml 10 08 25 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 61154**

Tuesday, August 10, 2010 8:40:57 AM



Page 5

Item ID: D2842-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly RH, 206 Float

Start Date: 8/11/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/08/125

H  
PW

230

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

PPP6/145

P 6/10/30 (4)

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/30 (4)

CL 10/18/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, August 10, 2010 8:40:56 AM

Page 1

Work Order ID: 61154

Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960C10L	NAS1149C0332 R	Purchased	No			100	Each	29.0000	3	12			
-----------	-------------------	-----------	----	--	--	-----	------	---------	---	----	--	--	--



washer

BT# 109545

Location

Loc Qty

Loc Code

ST245

29

107534

29

D2622-120C		Manufactured	No			110	Each	95.4200	1	4			
------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Step Extrusion

Location

Loc Qty

Loc Code

WA

95.42

55214

3.42

58544

92

D2734		Manufactured	No			110	Each	7.0000	2	8			
-------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Step End Plate

*\**

Location

Loc Qty

Loc Code

WA

B60216

7

55014

7

D3459-1		Manufactured	No			110	Each	32.0000	2	8			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Float Step Mounting Plate

Location

Loc Qty

Loc Code

WA

~~B60216~~

32

48138

10

51583

22



*mm 10-08-25*



*10-08-17*



*4  
8  
10-08-17*



*7  
1  
8  
10-08-17*

*8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, August 10, 2010 8:40:56 AM

Page 2

Work Order ID: 61154

Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

D3459-3  
  
 Manufactured No  
 Float Step Mounting Plate

210 Each 18.0000 2 8



*SL 10-08-17*

Location	Loc Qty	Loc Code
WA <i>B61214</i>	18	
46988	1	
51630	17	

*8*

MS27039C1-07  
  
 Purchased No  
 screw

210 Each 21.0000 3 12



*B# 115460*

Location	Loc Qty	Loc Code
ST293	21	
111424	21	

*ml 10-08-25*

NAS1329C3KB130  
  
 Purchased No  
 insert

210 Each 84.0000 3 12



Location	Loc Qty	Loc Code
ST276	84	
<u>111981</u>	84	

*ml 10-08-25*

NAS1515H3L  
  
 Purchased No  
 WASHER

210 Each 434.0000 3 12



Location	Loc Qty	Loc Code
FG	40	
102472	40	
ST277	394	
<u>111819</u>	148	
113362	246	

*ml 10-08-25*

Tuesday, August 10, 2010 8:40:56 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

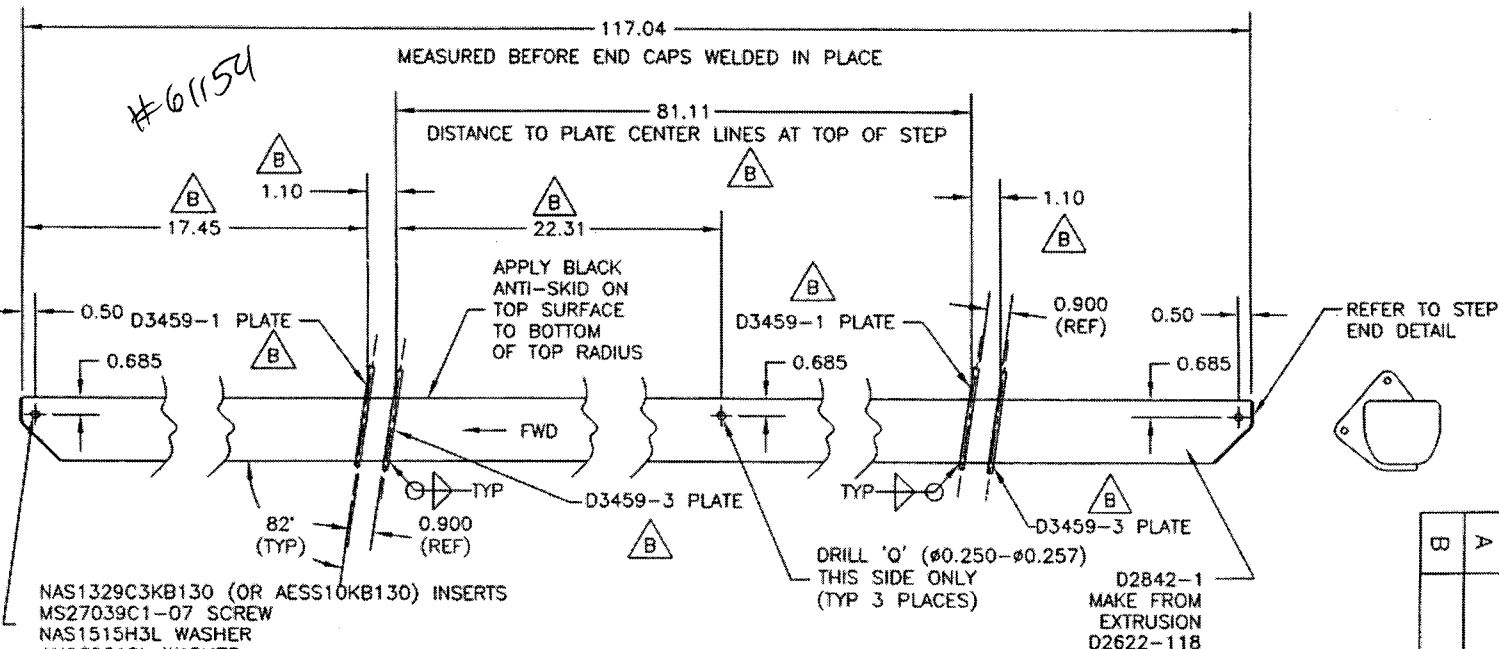
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

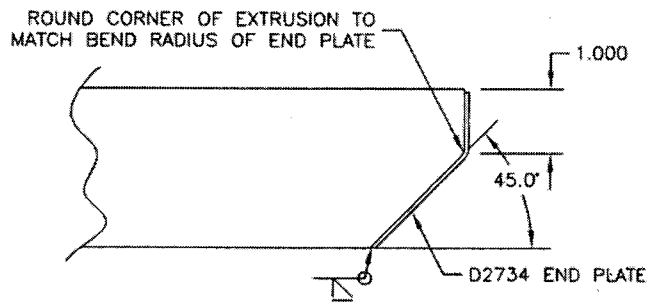


NAS1329C3KB130 (OR AESS10KB130) INSERTS  
 MS27039C1-07 SCREW  
 NAS1515H3L WASHER  
 AN960C10L WASHER  
 (TYP 3 PLACES)

**D2842-041 LH STEP ASSEMBLY (SHOWN)**  
**D2842-042 RH STEP ASSEMBLY (OPPOSITE)**

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



**TYPICAL STEP END DETAIL**  
 NOT TO SCALE

NOTE: ALL WELDS SHALL  
 BE 100% VISUALLY  
 INSPECTED BY A QUALIFIED  
 INSPECTOR PER DART  
 QSI 004

**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	PORT HADLOCK, WA
DATE	05.09.23			D2842	REV. B
				TITLE	SHEET 1 OF 1
				206L/407 FLOAT STEP ASSEMBLY	SCALE
				NEW ISSUE	NIS
				RE-DESIGN, ADD D3459-1/-3	

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2005 by DART AEROSPACE USA, INC.

RELEASED  
 05.11.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries